

Date: Tuesday, 09/06/2009 9:22:01 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIB ASSY (BASKET END)
Job Number : 48430	
Estimate Number : 13666	
P.O. Number :	Part Number : D3825041
This Issue : 09/06/2009 S.O. No. :	Drawing Number : D3825 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 47075	Material :
Written By :	Due Date : 15/06/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JUD 09-06-09</u>	
Comment : Est Rev:A 08-12-01 new issue DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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✓ 1.0	D23273	Spacer Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Spacer Bushing

Batch: B44274SAD 09-06-19 (6)

✓ 2.0	D37591	Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bushing

B46536SAD 09-06-19 (6)

✓ 3.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 2.2313 f(s)/Unit Total : 13.3875 f(s)

304 SQ Tube .75x.75x.065W

batch: M112051SAD 09-06-18 (6)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

- ✓ 1- cut D3825-1 rib as per dwg D3825
- ✓ 2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg and hole for bushing as per dwg
- ✓ 3- c/sink hole as per dwg
- ✓ 4- remove identification markings
- ✓ 5- deburr

SAD 09-06-18 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 09/06/2009 9:22:01 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (BASKET END)

Job Number: 48430

Part Number: D3825041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 09/06/18 (x6)

6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825

A/R ER316 S.S. Rod Batch: ~~M103431~~ M103775

2- grind bushing weld flush where indicated on dwg D3825

3- deburr if necessary

6x.
SP 09.06.19

7.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

SP 09.06.19

8.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/19 (x6)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

SAD 09-06-19 (6)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/06/19

Job Completion



MF
09-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

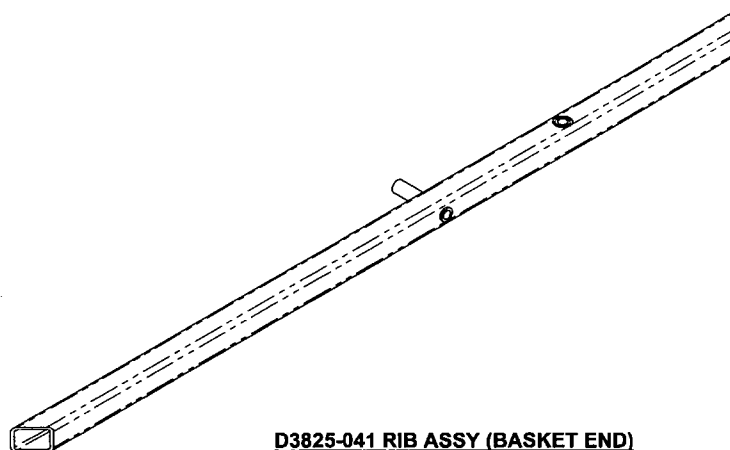
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
								/

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB



D3825-041 RIB ASSY (BASKET END)

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 148450

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.22 lbs
 - 8) WELDING: PER DART QSI 004

RELEASED
09/11/18/V

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3825	REV. A
TITLE RIB ASSY (BASKET END)	SCALE NTS
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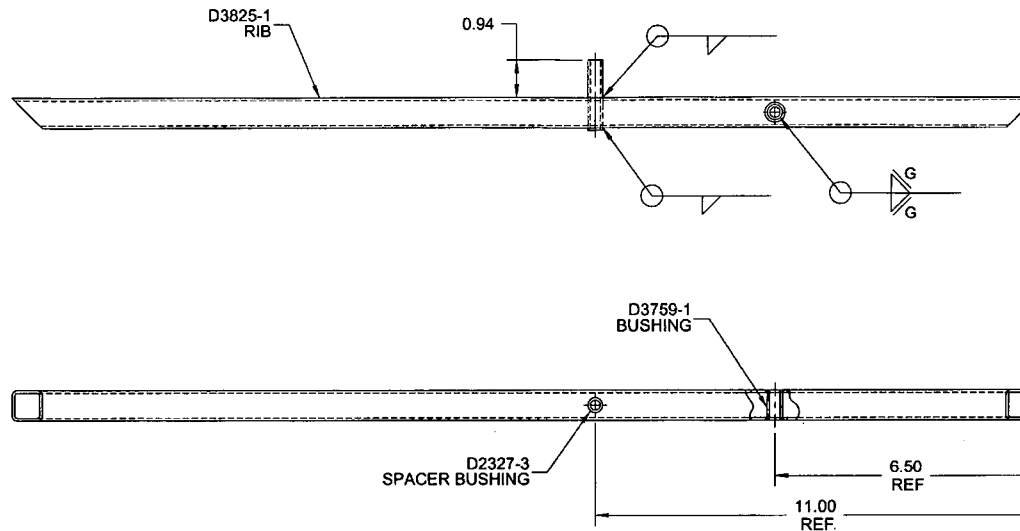
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3825-041 RIB ASSY (BASKET END)

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WORK ORDER
NO. 184230

RELEASED
08/11/18 NW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	N/S	DRAWING NO.	REV. A
MFG. APPR.	N/S	D3825	SHEET 2 OF 3
APPROVED	N/S	TITLE	SCALE
DE APPR.	N/S	RIB ASSY (BASKET END)	NTS
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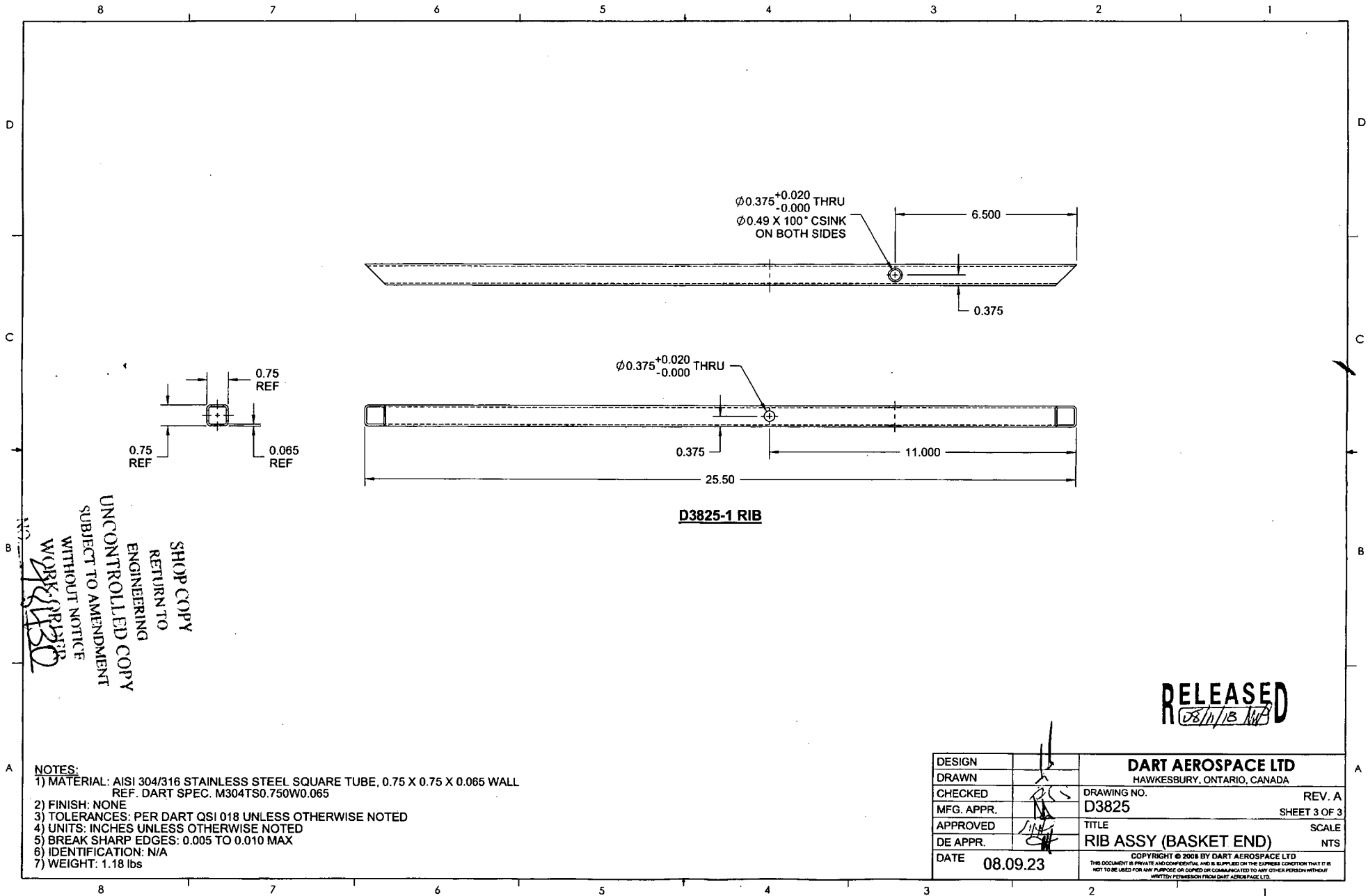
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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WORK RELEASED
2/1/20

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.18 lbs

RELEASED
08/11/13 NPB

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
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